



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3207-5

Job Sheet 193995



Part No: D3207-5

Job Qty: 8 pcs

DAS
21
9-89

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/11/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C SHEETS 5,6 IPP A 04.06.09 New issue KJ/RF IPP REV C AS PER REV B 12-03-23 JLM
VERIFIED BY:EC IPP REV:D 12.05.10 per dwg rev.c DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	6/11/19	6/11/19	0.00	0.44	Waterjet - Flow		ac 20/02/18 TF
120	QC 8	8 pcs	6/11/19	6/11/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	8 pcs	6/11/19	6/11/19	0.03	0.32	Small Fab - Brake - 1 - B4B		DAS 30 FEB 27 2020 9-89
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	8 pcs	6/11/19	6/11/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		

Plex 4/24/19 4:04 PM Dart.Renwick.Jennife

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
150 Handfinish - 1-1 Chemical-B4B	8 pcs	6/11/19	0.00 0.12		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
155 QC 7	8 pcs	6/11/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160 Powdercoat - 3 Grey Sand - B4B	8 pcs	6/11/19	0.00 0.15		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170 QC 3	8 pcs	6/11/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	

DAS
40
9-89
MAR 02 2020

MAR 02 2020

BEB 20-03-02

BEB 20-03-02

DAS
59
9-89

			QC 3 - 41	
			QC 3 - 51	DAS
			QC 3 - 58	82
			QC 3 - 59	9-89
			QC 3 - 68	MAR 03 2020
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
180 Packaging 3-1 - Stock - B4B	8 pcs	6/11/19	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
190 QC 21 - SA	8 pcs	6/11/19	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53
Part Op 100 - 1-Cut as per Dwg D3207 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 155 - (QC7-Inspect Chemical Conversion Coat) 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 12:40 TEMP: 320° FINISH: 1:10 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.5888 sf (.0736 ea)	100-Waterjet - Flow - 1	5237390
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.125	1	86	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	2.930inches $\pm$ 0.010	2.940 2.920	2.931	
2	Bracket	2.376inches $\pm$ 0.010	2.386 2.366	2.384	
3	Bracket	3.200inches $\pm$ 0.010	3.210 3.190	3.205	
4	Bracket	0.250inches $\pm$ 0.030	0.280 0.220	0.250	
5	Bracket	0.500inches $\pm$ 0.030	0.530 0.470	0.500	
6	Bracket	0.750inches $\pm$ 0.030	0.780 0.720	0.750	
7	Bracket	0.438inches + 0.005 - 0.000	0.443 0.438	0.438	

Plex 4/24/19 4:04 PM Dart.Renwick.Jennifer